



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No. CNC/QA/FM/02

Rev. No. 01

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		16094 do 16135	35/50
2	Machined By		V.T.L. H/c Shop	Dry No 21-9-2013
3	Pallet Die No.		15691 (3.5) H/c	
4	Die Category	Drg. No.	2nd side	
5	Out Side Diameter	Drg. No.	619.9 H/c	Step OD 2 611.9 H/c
6	Inside Diameter	Drg. No.	520.14 H/c	Step length 19.8 H/c
7	Width of Pellet Die	Drg. No.	222.6 H/c	
8	Grooves as per Drawing	Drg. No.	13.3 x 8r 5 H/c	13.3 x 8r 5 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping No
12	Tapping PCD		565 H/c	of Holes 212
13	Tapping Hole Diameter		H20, Check by H20 Ball	Both side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth = 20.5 H/c	Tapping depth = 18.4 H/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 26/9/25

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	OK
4	Defective Holes (If Any)		No

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	OK						Counter 260
2	External Relief Dia	3.8 H/c	20 Side (3-3)		Inner			Row 2 35
3	External Relief Depth		19 H/c		15 H/c			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Furnace			
6	Material Sent For Hardening On Date				26	9	25	
Inspected By (Sign) & Date			Ravi 26-9-25					

Reviewed by (Engineer-CNC)

Manager-QA